

Work Order ID 70150

Monday, May 30, 2011 11:26:02 AM



Page 1

Item ID:	D3546-1	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Clip					
Start Date:	5/30/2011	Start Qty:	12.00		Cust Item ID:	
Required Date:	6/10/2011	Req'd Qty:	12.00		Customer:	
Reference:						

Approvals:	Process Plan:	<u>MF</u>	Date:	<u>11-05-30</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3546	Rev A								

100	FLOW WATER JET	0.00							
	Waterjet								
FLOW CNC Waterjet	Memo	0.00							
304 . 050	1-Cut as per Dwg D3546								
	Dwg Rev: <u>A</u>								
	Prog Rev: <u>A</u>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
QC	Memo	0.00							
Quality Control									

- B11-6-1

(12)

B11-6-1

(42)

5/11/06/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 70150

Monday, May 30, 2011 11:26:02 AM



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Item ID: D3546-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Clip

Start Date: 5/30/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 6/10/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Brake NC Brake NC	NC BRAKE Memo Form as per Dwg D3546	0.00 0.00		SBS 110607					
140 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		S 110607					(X2)
150 Packaging Packaging	Identify as per dwg & Stock Location: 245 Memo	0.00 0.00							11/6/8 120 JD

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Work Order ID 70150

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Monday, May 30, 2011 11:26:02 AM

Item ID: D3546-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Clip

Start Date: 5/30/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 6/10/2011 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/6/11
mf
11-06-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

Monday, May 30, 2011 11:25:59 AM

Page 1

Work Order ID: 70150

Parent Item: D3546-1

Parent Item Name: Clip



Start Date: 5/30/2011



Required Date: 6/10/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 06-09-27 JLM
remove finish DD 10.03.29 verified by:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S18GA 		Purchased	No			100	sf	180.0000	0.04	0.505263			
											B 11-6-1		

304/316 .050 Sheet

Location

Loc Qty

Loc Code

MAT020

180

112178

4

113062

18

116135

20.5

116604

1.5

116979

69

117653

67

112178

18

W/O:		WORK ORDER CHANGES					
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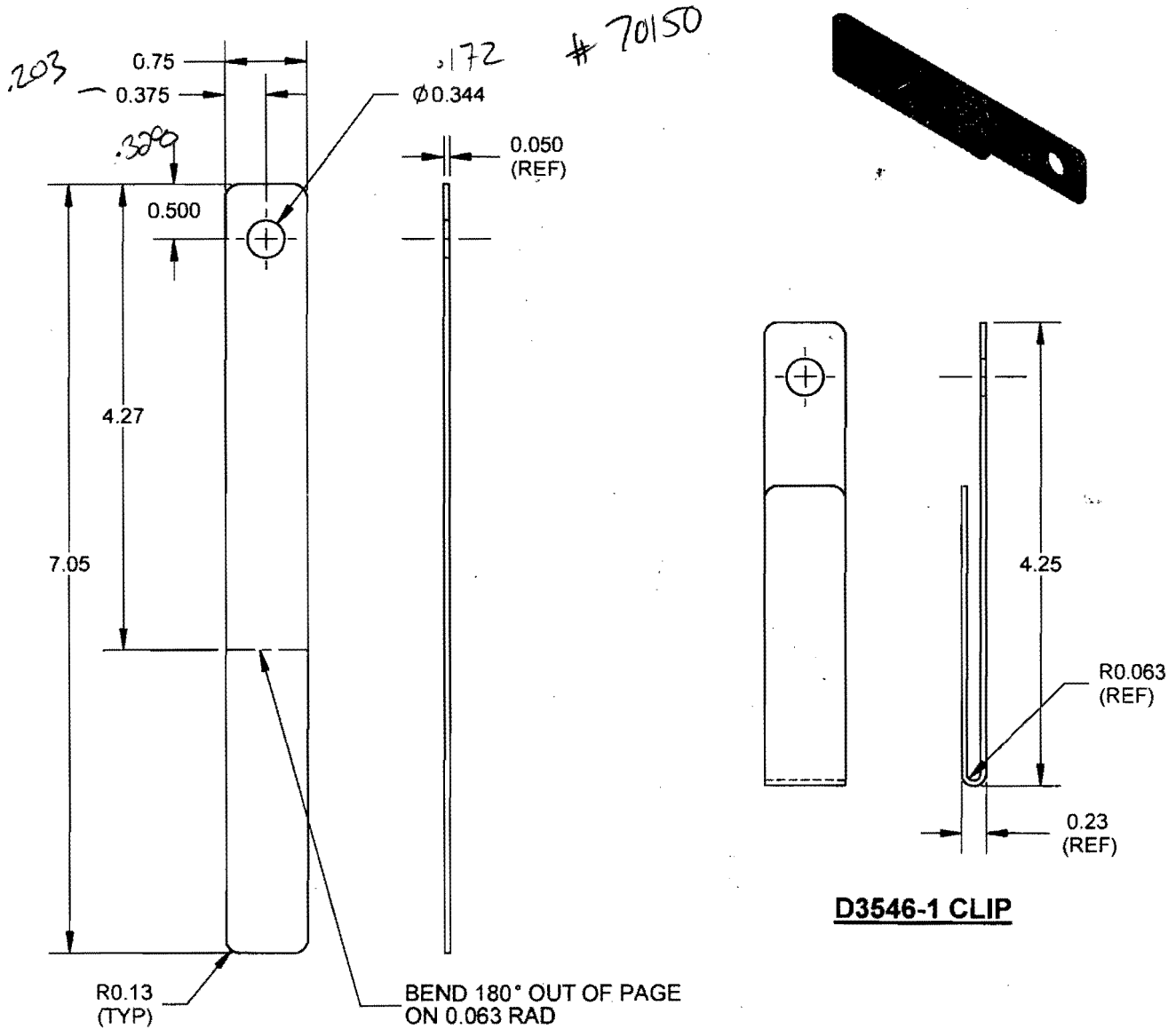
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DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>qp</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3546	REV. A SHEET 1 OF 1
DATE 06.09.15	TITLE CLIP		SCALE 1:1
REV A	DATE 06.09.15	DESCRIPTION NEW ISSUE	



D3546-1F FLAT PATTERN

D3546-1 CLIP

NOTES:

- 1) MATERIAL: 304/316 STAINLESS STEEL 0.050 THICK (REF. DART SPEC. M304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI.018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES TO 0.010 MAX

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